	Work Order ID 70897 Thursday, June 16, 2011 2:41:42 PM								ASPP			Page
Item ID: Revision ID: Item Name:	D3262-5 Cap	4	)	Accept					Setup	Start Stop		
Start Date: Required Date: Reference:	6/16/2011 6/20/2011	Start Qty: 4/00 Req'd Qty: 4/00	1881   8  8  1881   1881   8  8  1881		Cust Item I Customer:	D:					-	
Approvals:		an: MF	Date: [ -06-  Date:			ite:			Run	Start Stop		
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr										
D3262	Е											
Bandsaw Jeaspa Bandsaw		BAND SAW Memo Cut blanks	: 6.000" x 0.500" x 5.400" lo	0.00 0.00 ong Bar	lulou/24	/		4	· _ /			
HAAS CNC vertical	machine #1	Machine as FOLIO RE DWG REV	s per dwg D3262 s per Folio FA902 and Dwg V:	0.00 0.00 D3262	11/04/24			4		<u></u>		

<b>Dart Aerospace Ltd</b>	
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W/O:			WC	ORK ORDER CHANG	GES				
DATE	STEP	PRO	OCEDURE CHA	EDURE CHANGE			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Ye	es No DQ	A:	_ Date: _	
,	R	esolution:	Dispositio	n:	QA: N/C	Closed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (N	CR)			
DATE	STEP	Description of NC	Corrective Action Section B				cation		Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Di	n & Sec	tion C	Chief Eng	QC Inspector
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Thursday, June 16, 2011 2:41:43 PM

Item ID:

D3262-5

**Revision ID:** 

Item Name:

Cap

Start Date: 6/16/2011

Required Date: 6/20/2011

Start Qty: 4.00

Req'd Qty: 4.00

Accept



Setup Start

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

QC:

Date:

Date: \_\_\_\_\_

Tooling:

SPC (Y/N):

Tool ID

Date: Date:

Tool # Plan

Run

Start

Stop

Stop

Sequence ID/ Work Center ID

120

Operation Description

QC2- Inspect parts off machine FAI/FAIB

Memo

Set Up/ **Run Hours** 

0.00

and 11/01/24

Qty Code

Accept

Reject Qty

Reject Insp. Number Stamp

Quality Control

130

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

11.0.27

140

QC

Packaging Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

4 1106.27

Dart Aerospace L	td
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W/O:			WC	RK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cated	gory:	NCI	R: Yes I	No <b>DQ</b>	A:	Date: _	
	Re	esolution:	Disposition	າ:	QA	N/C Clo	sed:		Date: _	
NCR:				ER NON-CONFORM	ANCE	(NCR)	)			
DATE	STEP	Description of NC		ction B	Sign & Verification C				Approval	
	J. 2.	Section A	Initial Chief Eng	Action Description Chief Eng		Date	Sect	ion C	Chief Eng	QC Inspector
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## Work Order ID 70897



Page 3

Thursday, June 16, 2011 2:41:43 PM

Item ID:

D3262-5

Accept



Setup Start

Stop



**Revision ID:** 

Cap Item Name:

6/16/2011 **Start Date:** 

Required Date: 6/20/2011

Start Qty: 4.00

**Req'd Qty:** 4.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

QC:

Operation

Description

Date: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N):

Tooling:

Set Up/

Run Hours

Date:

Tool ID

Date:

Tool # Plan

Code

Run

Accept

Qty

Start



Stop

Sequence ID/

**Work Center ID** 

150

Memo

QC21- Final Inspection - Work Order Release

0.00

0.00

Reject

Qty



Number Stamp

Insp.

Reject

Quality Control

Dart	<b>Aeros</b>	pace	Ltd

Dart Ae	rospace L	_td							* 3
W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	Part No: PAR #:		Fault Cat	tegory:	NCR: Yes	lo DQA:		_ Date: _	
Resolution:			Dispositi	on:	QA: N/C Clo	sed:		Date: _	
NCR:		V	VORK ORI	DER NON-CONFORMAN	ICE (NCR)				
DATE	STEP	Description of NC	Corrective Action		Section B		tion	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	С	Chief Eng	QC Inspector
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	1								

## Picklist Print

Thursday, June 16, 2011 2:41:34 PM

Work Order ID: 70897

Parent Item:

D3262-5

Parent Item Name: Cap

6061-T6 Bar .500 x 6.00



**Start Date:** 6/16/2011

Required Date: 6/20/2011

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP REV:A NEW ISSUE 10-01-19 JLM VERIFIED BY:EC

Rev:B as per ECN10-571 DD 10.05.10 verified :EC

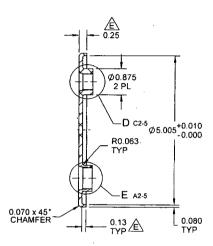
IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X06.00		Purchased	No	,		100	f	42.0000	0.96	4.042105			

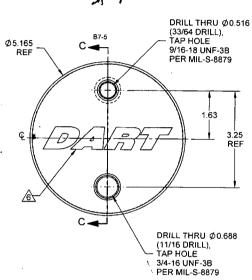
<b>Location</b>	Loc Qty	Loc Code		
MAT004	42			
<b>-3</b> 112567	22		4.05	ankido6/24
115045	20			ť

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W/O:			· V	ORK ORDE	R CHANG	ES					
DATE	STEP	PR	OCEDURE CH	IANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Ca	tegory:	<b>'</b>	_ NCI	R: Yes	No <b>DQ</b>	<b>A</b> :	Date:	
	Re	esolution:	Disposit	ion:	i e	QA	N/C CI	osed:		Date: _	
NCR:			WORK OR	DER NON-C	ONFORM	ANCE	(NCR	)			
	OTED	Description of NC	Corrective Action Section B					Verific	eation	Approval	Approval
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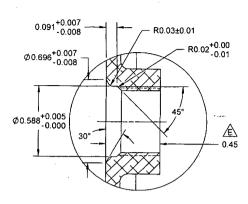
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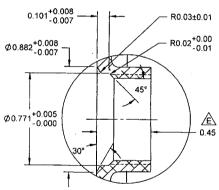
SECTION C-C D5-5



D3262-5 CAP



2



DETAIL E B7-5

С

DESIGN	RF	DART AEROSPACE LTD							
DRAWN	R <b>F</b>	HAWKESBURY, ONTARIO, CANADA							
CHECKED	<b>\$</b>	DRAWING NO.	REV. E						
MFG. APPR.	9/	D3262 s	HEET 5 OF 5						
APPROVED	140	TITLE	SCALE						
DE APPR.	-#	FUEL PURGE CANISTER	NTS						
DATE 10.0	5.03	COPYRIGHT © 2004 BY DART AEROSPACE L THIS DOCUMENT IS PRIVATE AND COMPORTING HOUSE EXPENDED ON THE EXPENSES OF HOT TO BE USED FOR ANY PRIPADOSE OR COMPANION AND PRIVATE OF THE PRINCIPLE OF THE	PLANT WORTHON						

NOTES: 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR PER QQ-A-200/8 OR QQ-A-225/8 REF. DART SPEC. M6061T6B

8

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN

7) WEIGHT: 0.27 lbs
8) PART IS SYMMETRICAL ABOUT CENTERLINE

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8

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<b>Dart Aerospace Li</b>	.td
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W/O:			WO	RK ORDER CHANGE	S		****			
DATE			OCEDURE CHAN	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No:										
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Part No: PAR #:		Fault Categ	ory:	NCR: Yes	NCR: Yes No DQA:					
Resolution:			Disposition	Disposition: Q			A: N/C Closed: Date:			
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	₹)	,			
DATE	STEP	Description of NC	ļ						Approval	
		Section A	Initial Chief Eng	Action Description Chief Eng			on C	Chief Eng	QC Inspector	
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					٠	By Date Qty Chief Eng / Prod Mgr QC Inspector  CR: Yes No DQA: Date:  A: N/C Closed: Date:  CE (NCR)  Verification Approval Approval Approval				

DART AEROSPACE LTD	Work Order:	70897		
Description: Cap	Part Number:	D3262-5		
Inspection Dwg: D3262 Rev: E		Page 1 of 1		

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.45	+/-0.030	440			Vern	ML7
0.25	+/-0.030	. 250			t e	4
Ø0.875	+/-0.010	0.875		·	1 \	<b>)</b> (
Ø5.005	+0.010/-0.000	\$5.005				1(
R0.063	+/-0.010	R.063			R-6	
0.080	+/-0.010	.078	/		Vern	11-7
0.13	+/-0.030	.129	_		l'	(1
0.070 x 45°	+/-0.010 x 0.5°	.073 × 45°			, ,	, (
Ø5.165 Ref	+/-0.010	\$5.166			+ 6 .	, (
1.63	+/-0.030	1.624	_		26	A.
, 3.25 Ref	+/-0.030	3.248			n	A C
9/16-18 UNF-3B	N/A	9/16-18 UNF	_		1.0	٠,
3/4-16 UNF-3B	N/A	34-16 UNF			• -	1.
0.091	+0.007/-0.008	.090	_		Vern	MIZ
R0.03	+/-0.010	R.630	_		R-6	
R0.02	+0.00/-0.01	R.020			, (	
45°	+/-0.5°	450	/		conse	41
30°	+/-0.5°	30°	-		consqu	
Ø0.588	+0.005/-0.000	0,588	_		Vem	nl-7
Ø0.696	+0.007/-0.008	B.695			, ,	14
		, -				
0.101	+0.008/-0.007	-101			1 (	/(
R0.03	+/-0.010	R.636			R-G	
R0.02	+0.00/-0.01	R,020			il	
45°	+/-0.5°	. 450			with	inose
30°	+/-0.5°	30°			0	
Ø0.771	+0.005/-0.000	8.772	_		Vern	774-7
Ø0.882	+0.008/-0.007	Ø.882			/(	11

Measured by:	and	Audited by:	20	Preliminary Approval:	
Date:	11/06/24	Date:	11.6.27	Date:	

Rev	Date	Change	Revised by	Approved
Α	10.06.07	New Issue	KJ 🛠	2
			171	

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W/O:			WORK ORDER CHANGES									
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			Fault Category: NCR: Yes No DQ						Date:			
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	0===	Description of NC	Corrective Action Section E			Verific		Approval	Approval			
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